

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009155**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing / Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Assembly Bay 14

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL1) to (FL2-2) of weld joint SEG056 SSD16A PP80 OBG assembly weld number 127 for Segment 9BE. The ZPMC welder identified as 067609 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL1) to (FL2-2) of weld joint SEG056 SSD16A PP80 OBG assembly weld number 133 for Segment 9BE. The ZPMC welder identified as 067609 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-Tc-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) on Floor Beam (FL1) to (FL2-2) of weld joint SEG056 SSD16A PP80 OBG assembly weld numbers 128 and 129 for Segment 9BE. The ZPMC welder identified as 067609 was welding in the 4F position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2114-FCM-1.

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Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to (FL2-2) of weld joint SEG 064B for OBG assembly weld numbers 010, 017, 018, 023, 024 for Segment 10CE. The ZPMC welders identified as 050242 was welding in the 2G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to (FL2-2) of weld joint SEG 064C for OBG assembly weld numbers 010, 017, 018, 023, 024 for Segment 10CE. The ZPMC welders identified as 050242 was welding in the 2G position. The ZPMC QC identified as Zhong Guo Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to Corner Assembly of weld joint SEG 056 SSD16A PP80 for OBG assembly weld numbers 008 and 001 for Segment 9DE. The ZPMC welders identified as 044795 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam (FL1) to Corner Assembly of weld joint SEG 056 SSD18A PP82 for OBG assembly weld number 009 for Segment 9DE. The ZPMC welders identified as 044774 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No relevant conversations spoken on this date.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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